

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007454**Date Inspected:** 26-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

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|------------------------------------|--------------|----|-----|
| CWI Name: | Pin-Tang Hsu | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | | |
|----------------------------------|--------------------------------------|----|-----|
| CWI Present: | Yes | No | |
| Rod Oven in Use: | Yes | No | N/A |
| Weld Procedures Followed: | Yes | No | N/A |
| Verified Joint Fit-up: | Yes | No | N/A |
| Approved WPS: | Yes | No | N/A |
| Delayed / Cancelled: | Yes | No | N/A |
| Component: | Tower, Jacking and Deviation Saddles | | |

Bridge No: 34-0006**Summary of Items Observed:**

On this date, 6/26/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W1 ~ Assembled Section has now been Post Weld Heat Treated and being cleaned by shot blasting.

W2W2 ~ QA Inspector observed welders S.Watanabe 08-5159 and M.Matuda 08-5151 following procedure SJ-3011-7 as they used SMAW process, 4.8mm E9018 electrode on welds identified as W3Y-4U-1 and -2 respectively, monitored by QC CWI Mr. Chung Fu Kuan and later by CWI Pin-Tang Hsu.

W2W3 ~ Saddle Casting is located in No. 4 Fabrication Shop idle. Built up Plate Section was observed by QA Inspector awaiting shot blast cleaning, then layout, also in Fabrication Shop #4.

TOWER SADDLES

T1-2 ~ Welding on this Tower Saddle in the Fabrication Shop #4 is by T.Watanabe 08-5153 on stiffener 8ST-21 and M.Kashiwada 08-2008 on stiffener 8ST-24 using FCAW process, 1.6mm TM55 consumable wire and procedure SJ-30128-2 these operations continued through to Night Shift CWI Mr. Pin-Tang Hsu, where random verification of set parameters were monitored. See comments below regarding conversation held between JSW representatives and this Caltrans QA Inspector.

WELDING INSPECTION REPORT

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EAST SADDLES

E2E1 ~ ECS response awaiting approval, casting awaits in Foundry. Splay plate cover has been sent out for Post Weld Heat treat.

E2W1 ~ Casting has had weld repair reinforcements carbon arc'd followed by mechanical grinding and now sits idle in Foundry. Discussion regarding the identification of Casting can be found below in "conversations and comments section".

West Jacking Saddle ~ Cast Section is being carbon arc shaped in the Foundry by one individual.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

On this day, 6.26.2009 QA Inspector Mike Brcic had opportunity to verify, with JSW representative Hideaki Kon, a condition as it relates to East Saddle E2W1, currently in Foundry. The identification irregularity was first noted by Mr. Brcic while reviewing an ECS documents BG-ECS-08-030, -031, -033, regarding repairs to be made by foundry personnel to the Saddle Castings. All three documents have a saddle sketch having the Identifying Marking on side opposite of plan/drawing requirement. But not until today was it noted that the actual stamping was in fact on the incorrect side. Mr. Kon and QA Inspector have ensured there has been no resultant traceability errors stemming from the irregularity as they apply to weld repair locations. Correction will be confirmed and documented at that time.

Later in the QA Inspector's shift, JSW Representatives Mr. K.Sato and Mr. H.Kon met with this Caltrans inspector to inform him of their intention to excavate the indications found on CJP welds of T1-2 between "C" shift 6.26.09 and "A" shift 6.30.09. Weld joints are as follows, 8Y-12L-4, 8Y-5L

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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| Inspected By: | Brcic,Michael | Quality Assurance Inspector |
| Reviewed By: | Peterson,Art | QA Reviewer |
